

Work Order ID 58507

May 7, 2010 3:05:47 PM

Page 1

Item ID: D3942-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 07/05/2010 Start Qty: 12.00

Required Date: 24/05/2010 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-5-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW CNC Waterjet

304, 050

Memo

1-Cut as per Dwg D3942-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

10-5-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

SB 10/05/14

29

29

10-5-13

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.06.05/14

count

25

45

P10 →

24

130

Memo

0.00



Brake NC

Memo

0.00

Brake NC

1- Bend as per dwg D3942

8.06.08/17

24

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.06.05/17

count

724

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3942- PAR #: _____ Fault Category: Small P/L NCR: Yes No DQA: _____ Date: 10/05/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/05/18

NCR: <u>58502</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/5/14	#120	Found at inspection that Qty of parts are are cut too short. R.C. machine malfunction	<u>JSUM</u>	-Scrap + Destroy qty x5 no replace only need 20 20 parts	<u>JSUM</u> 10/5/14	<u>JSUM</u> 10/05/13	<u>JSUM</u>	<u>JSUM</u> 10/05/13

NOTE: Date & initial all entries

Work Order ID 58507

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Revision ID:

Stop



Item Name: Angle

Start Date: 07/05/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 24/05/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

Identify as per dwg & Stock Location: 98

0.00



Packaging

Memo

0.00

Packaging

10-5-17 6409

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/18

MF
10-5-17

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 58507



Parent Item: D3942-1



Parent Item Name: Angle


Start Date: 07/05/2010

Required Date: 24/05/2010

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	141.1179	0.015	15		



1810-5-13

Location

Loc Qty

Loc Code

MAT20

141.1179

108156

1.7

111743

10.1

112885

33.3179

113062

96

112885

29

W/O:			WORK ORDER CHANGES					
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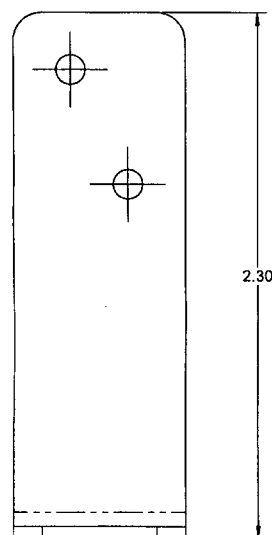
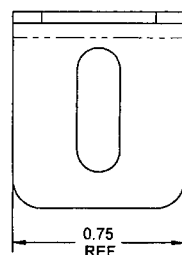
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6 SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 58307

BS10-5-10



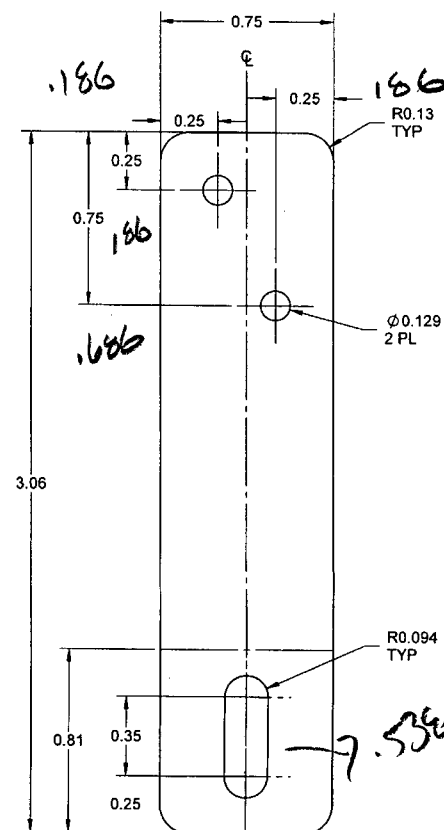
0.050
REF

R0.06

D3942-1 ANGLE
 MADE FROM D3942-1F

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
 18 GAUGE (0.050 THICK)
 REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs



D3942-1F FLAT PATTERN

RELEASED
09/05/06

A NEW ISSUE		BY DATE	
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.06		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3942	REV. A
TITLE BRACKET	SCALE NTS

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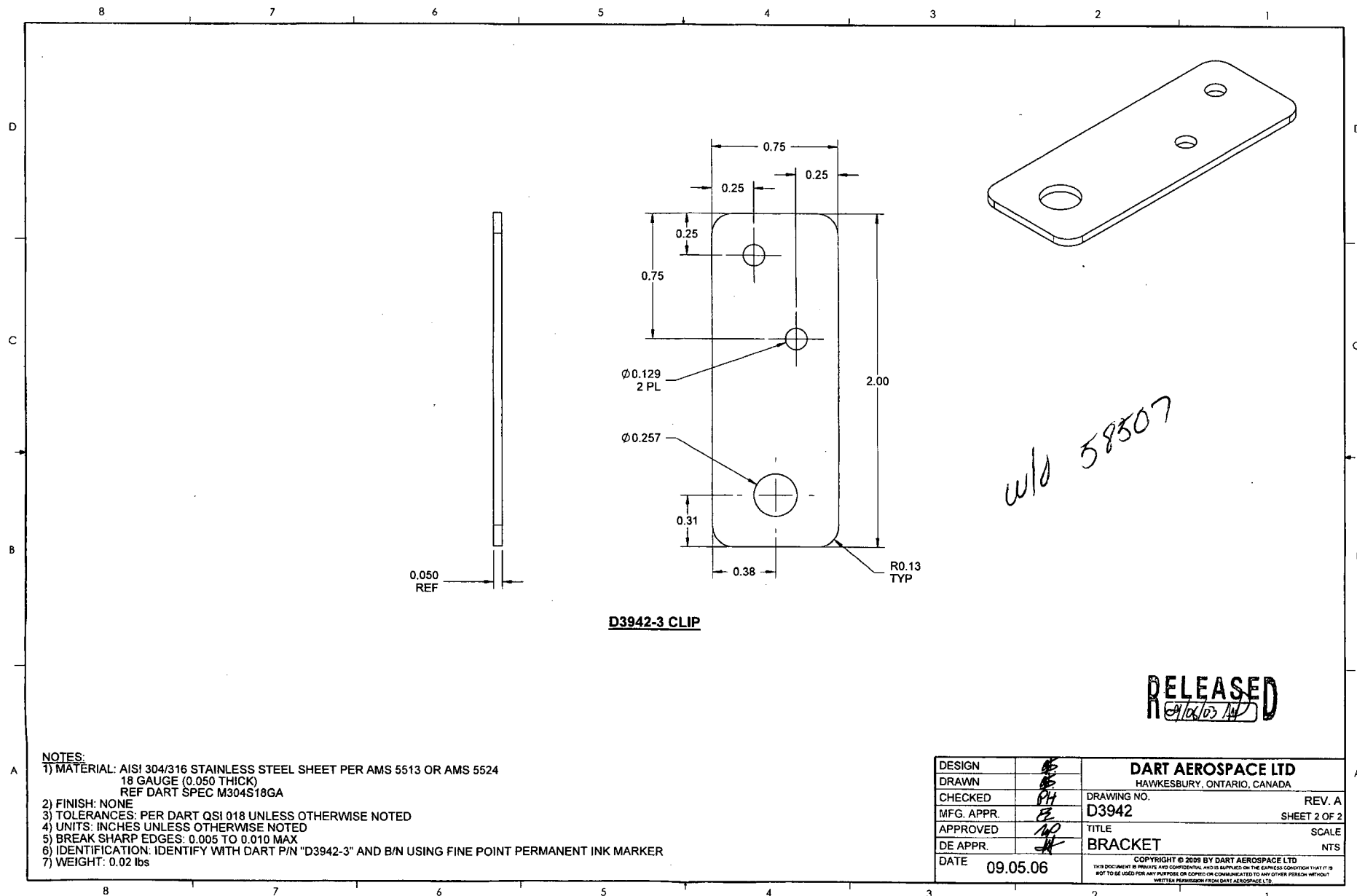
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